



Galvany Shopprimer IZ182(C) (Two-Component)

Product Description	A self-curing, zinc filled inorganic coating. Liquid and Zinc Paste mixed prior to application. It is specially designed weldable inorganic primer. Welds made over Galvany Shopprimer IZ182(C), coated steel are equal in every respect to welds joining uncoated steel prior to fabrication. It protects the substrate from corrosion with cathodic protection mechanism in normal and marine environments. Welds spatter does not adhere to damage the coating. Coated steel can be welded as quickly and easily as bare steel at production line speeds, with no loss in strength or consistency of the weld. Dry to touch paint and coatings. Approved as a Prefabrication primer by Det Norske Veritas (DNV), Lloyd's Register of Shipping (LR) and American Bureau of Shipping (ABS).
Recommended Use	As a shopprimer in shipyards, tank and structural steel fabricating shops and steel mills. It has many cost saving advantages over conventional shopprimer. Not recommended for exposure to acids and alkalis.

Physical Properties

Finish and Color	Flat. Grey			
Drying Time (with 65% R.H.)	Substrate temperature	5 °C/41 °F	20 °C/68 °F	30 °C/86 °F
	Set to touch	40 min	10 min	5 min
	Dry through	12h	5 h	4 h
* The actual drying time is subject to the film thickness, ventilation, humidity etc., and drying time under other temperature conditions should be checked and informed by KCC.				
Solids by Volume	Approx. 30 %			
Theoretical Spreading Rate	20 m ² /L in 15 µm dry film thickness on a smooth surface.			
Specific Gravity	Approx. 1.20 for Mixture of Paste and Liquid.			
Flash Point	Liquid	: 13 °C/55 °F (Closed cup)		
	Paste	: 4 °C/39 °F (Closed cup)		

Application Details

Surface Preparation	Remove any oil, grease, dirt and any other contaminant from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc. * Steel : Blast cleaning to Sa2.5 to obtain 25 ~ 40 microns blast profile.		
Application Conditions		Substrate Temperature	Relative Humidity
	Normal	4 °C ~ 49 °C	40% ~ 80%
	Min.	-18 °C	10 %
	Max.	93 °C	85 %
Special thinning and application techniques may be required above or below normal conditions.			
Mixing	Liquid : Paste = 4 : 6 (by volume) Mix separately, then combine and mix the mixture thoroughly prior to application. Use the mixture after filtering with 50 mesh screen.		
Pot Life	24 h at 20 °C/68 °F		
Thinning	Under the temperature condition below 25 °C/77 °F, diluted up to 40% by volume with Thinner No. 0608. Under the temperature condition above 25 °C/77 °F or windy, use Thinner No. 0614.		

Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.



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Application Method	Special thinning and application techniques may be required above or below normal conditions. Spray : Use adequate air volume for correct operation. Hold gun 8 ~ 10 inches from the surface and at a right angle to the surface. Use a 50% overlap with each pass of the gun on irregular surfaces, coat the edges first, making an extra pass later. * For airless spray application ; Nozzle orifice : 432 ~ 584 μm (0.017" ~ 0.023") Output pressure : 9.6 ~ 12.4 MPa Fan : 45 ° ~ 90 ° * For conventional spray : Use agitated pot and maximum 50 feet hose. Keep pot at same elevation as gun. If spraying stops for more than 15 minutes, blow material from hose back into pot. * For Brush or Roller ; For minor touch-up coating only. Use medium bristled brush. Apply with full brush and avoid rebrushing.																												
Typical Film Thickness	15 ~ 25 μm dry.																												
Recoating Interval	At 25 °C and above 60 % R.H., Minimum : 6 h Maximum : Free																												
Subsequent Coat	Inorganic Zinc Silicate, Epoxy, Coal tar Epoxy, Vinyl, Chlorinated Rubber and Heat resistant paint, or proper coatings can be applied over Galvany Shopprimer IZ182(C). Apply directly to the substrate compatibility with other coatings.																												
Shelf Life	12 months																												
Heat Resistance	Continuous : 400 °C / 752 °F (Non-immersion service) Non-continuous : 427 °C / 800 °F (Non-immersion service)																												
Chemical Resistance	<table><tr><th></th><th>Acids</th><th>Alkalies</th><th>Solvents</th><th>Salts</th><th>Water</th></tr><tr><td>Splash & Spillage</td><td>Fair</td><td>Fair</td><td>Excellent</td><td>Excellent</td><td>Excellent</td></tr><tr><td>Fumes</td><td>Good</td><td>Good</td><td>Excellent</td><td>Excellent</td><td>Excellent</td></tr><tr><td>Immersion</td><td>NR</td><td>NR</td><td>Excellent</td><td>NR</td><td>NR</td></tr></table> * NR : Not Recommended.						Acids	Alkalies	Solvents	Salts	Water	Splash & Spillage	Fair	Fair	Excellent	Excellent	Excellent	Fumes	Good	Good	Excellent	Excellent	Excellent	Immersion	NR	NR	Excellent	NR	NR
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Standard Packing Unit	18 L (Liquid : 7.2 L, Zinc Paste : 10.8 L)																												
Remarks	Automatic welding : About 48 inch per minutes of welding rod speed is recommended for Galvany Shopprimer IZ182C applied steel. It is depends on the thickness of steel plate and welding rod. This includes the following process; 1) Submerged arc. 2) Flux core. 3) Short arc. 4) Metal inert gas(MIG) Manual welding : Galvany Shopprimer IZ182(C) can be easily welded by all electrodes with MIL-E numbers between 6010 and 10018. Skin can be shown on Galvany Shopprimer IZ182(C) if it left in opened cans. Skin has no effect on performance, but should be removed before using. Clean tools with Thinner No. 0608 or No. 002 immediately after use. Remove hardened material with 10 % caustic solution.																												
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